

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004783**Date Inspected:** 13-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Island, Shanghai**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

Part # FB003-110.

1. The QA Inspector performed a random Visual (VT) and Magnetic Particle Testing (MT) verifications on the completed fillet welds made between assembly component members on the inspection part FB003-110 of the OBG floor beam (please note that multiple welds were verified on this inspection part). Please see the ZPMC Non Destructive Examination (NDE) notification document number 001396 for additional information. The QA Inspector performed the VT and MT verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for the QA Inspector verification. The QA Inspector performed the verifications on one side of the inspection part only due to the other side was previously verified by other QA Inspector. The QA Inspector observed a welding discontinuity on the weld number 067 that appeared not to meet the minimum specification requirements (under cut) that will require welding repair. The QA Inspector notified ZPMC and ABF QC Inspection personnel of the discontinuity observed.

The ZPMC QC Inspector Li Jia relayed to QA Inspector welding repair will be performed at this location. The QA Inspector did not witness the welding repair due to other verifications needed to be performed on this shift. After the welding repaired was completed the QA Inspector observed the fillet weld appeared to be in general compliance. The QA Inspector did not observe any relevant indications during the MT verification. The QA

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Inspector notified Task Leader Albert Carreon of the observations during verification. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Part # FB059-004.

2. The QA Inspector performed a random VT and MT verification on the completed fillet welds made between assembly component members on inspection part FB059-004 of the OBG floor beam. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed their inspections and reported the welds to be acceptable and ready for verification. Please note that multiple welds were verified on this inspection part assembly. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001396 for additional information. The QA Inspector performed the verifications on one side of the inspection part only due to the other side was previously verified by other QA Inspector. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during the verifications. The QA Inspector notified Task Leader Albert Carreon of the observations during verification. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Part # FB003-093.

3. The QA Inspector performed a random VT and MT verification on the completed fillet welds made between assembly component members on inspection part FB003-093 of the OBG floor beam. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed their inspections and reported the welds to be acceptable and ready for verification. Please note that multiple welds were verified on this inspection part assembly. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001402 for additional information. The QA Inspector performed the verifications on both sides of the inspection part. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during the verifications. The QA Inspector notified QC Inspector and Task Leader Albert Carreon of the observations during verification. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Part # FB003-099.

4. The QA Inspector performed a random VT and MT verification on the completed fillet welds made between assembly component members on inspection part FB003-099 of the OBG floor beam. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed their inspections and reported the welds to be acceptable and ready for verification. Please note that multiple welds were verified on this inspection part assembly. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001402 for additional information. The QA Inspector performed the verifications on one side of the inspection part assembly only due to the other side was previously verified by other QA Inspector. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during the verifications. The QA Inspector notified ZPMC QC Inspection personnel and Task Leader Albert Carreon of the observations during verification. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

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Part # FB056-001.

5. The QA Inspector performed Ultrasonic Testing (UT) verification on a weld repaired area made on the Complete Joint Penetration (CJP) butt splice weld identify as weld number FB056-001-023 on inspection part FB056-001. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001389 for additional information. The QA Inspector performed the UT verification after ZPMC QC Inspectors reported the weld to be acceptable and ready for verification. The QA Inspector did not observe any rejectable welding discontinuities on the verified weld. The QA Inspector notified ZPMC QC Inspection personnel and Task Leader Albert Carreon of the QA Inspector verification results. Please see the QA Inspector Ultrasonic Test report (TL 6027) generated on this date for additional information.

Summary of Conversations:

As noted in the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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